

Date: Wednesday, 27/08/2008 12:38:25 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: PLUG - BLUE		
Job Number	41636						
Estimate Number	10512						
P.O. Number	:			Part Number	: D26511		
This Issue	: 27/08/2008 S.O. No. :			Drawing Number	: D2651 REV. B		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / / Type : MACHINED PARTS			Drawing Revision	: B		
Previous Run	: 41112			Material	:		
Written By	:			Due Date	: 03/09/2008 Qty: 100 Um: Each		
Checked & Approved By	:						
Comment	: Est: A 02.04.15 New Issue NG						
	Est: B 05.12.12 added deburr EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0500	6061-T6 Round Bar .500" 42942
		102
		Comment: Qty.: 0.0421 f(s)/Unit Total : 4.2105 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: M107676
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 102
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651 2- Deburr
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 102
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK 102
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 102
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr ias per dwg D2651 FB 8-9-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 12:38:26 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG - BLUE

Job Number: 41636

Part Number: D26511

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



102X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m/f

08/09/16

7.0 SPRAY PAINTING

SPRAY PAINTING



102X

Comment: SPRAY PAINT DELFLEET BLUE

CLEAR DELFLEET

Batch _____

(Only larger section necessary)

Powder coat
white per QSI 005

M108523

m/f 08/09/24

8.0 QC2

INSPECT SPRAY PAINT



102X

Comment: INSPECT SPRAY PAINTING

FZ

08/09/24

9.0 PACKAGING 1

PACKAGING RESOURCE #1



102X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-P-A

m/f

08/09/24

10.0 QC21

FINAL INSPECTION/W/O RELEASE



102X

Comment: FINAL INSPECTION/W/O RELEASE

08/09/26 ff

Job Completion



m/f 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



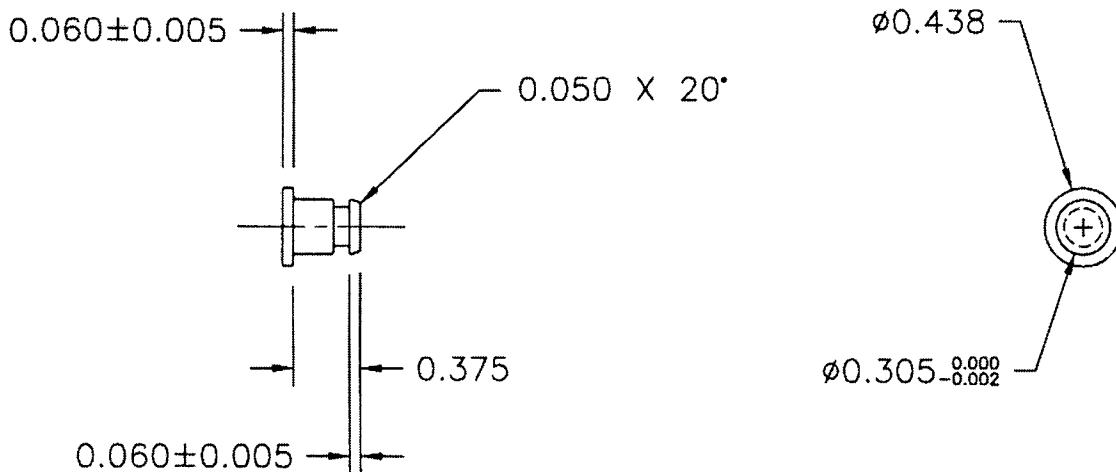
DO NOT COPY OR REUSE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

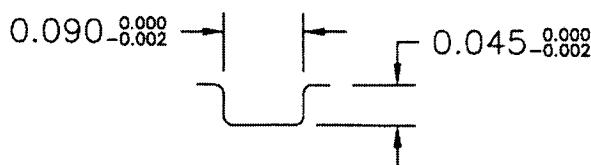
RELEASED

03.12.19 *[Signature]*

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



4/0
4/636

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41636
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	MMP	Audited by:	<u>cmf</u>	Prototype Approval:	N/A
Date:	08/08/27	Date:	08/08/27	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	PP